

Date: Wednesday, 8/30/2006 11:57:01 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28357
Estimate Number : 12493
P.O. Number :
This Issue : 8/30/2006 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-07-26 JLM

Drawing Name : GPS RECEIVER HOUSING
Part Number : D35145
Drawing Number : UNDER REVIEW CB 06.08.30
Project Number : N/A
Drawing Revision : N/A
Material :
Due Date : 9/6/2006 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.2518 sf(s)/Unit Total: 0.2518 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: MT06742

SAD 06:09:03

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: CB "Prel"

Prog Rev: "Prel"

Ensure Grain Direction is correct**

2-Deburr if necessary

SAD 06:09:03

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:09:03

①

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 06:09:05 ①

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514

SAD 06/09/06 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 7/10/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:57:01 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28357

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB 04/09/06

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-06 (1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. 06-09-12 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-09-13 1

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and check

Location: _____

for eng. use only

06-09-19 (1)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07-10-31-08 (1)

Job Completion



06-09-20

Eng Approval

CB 07.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

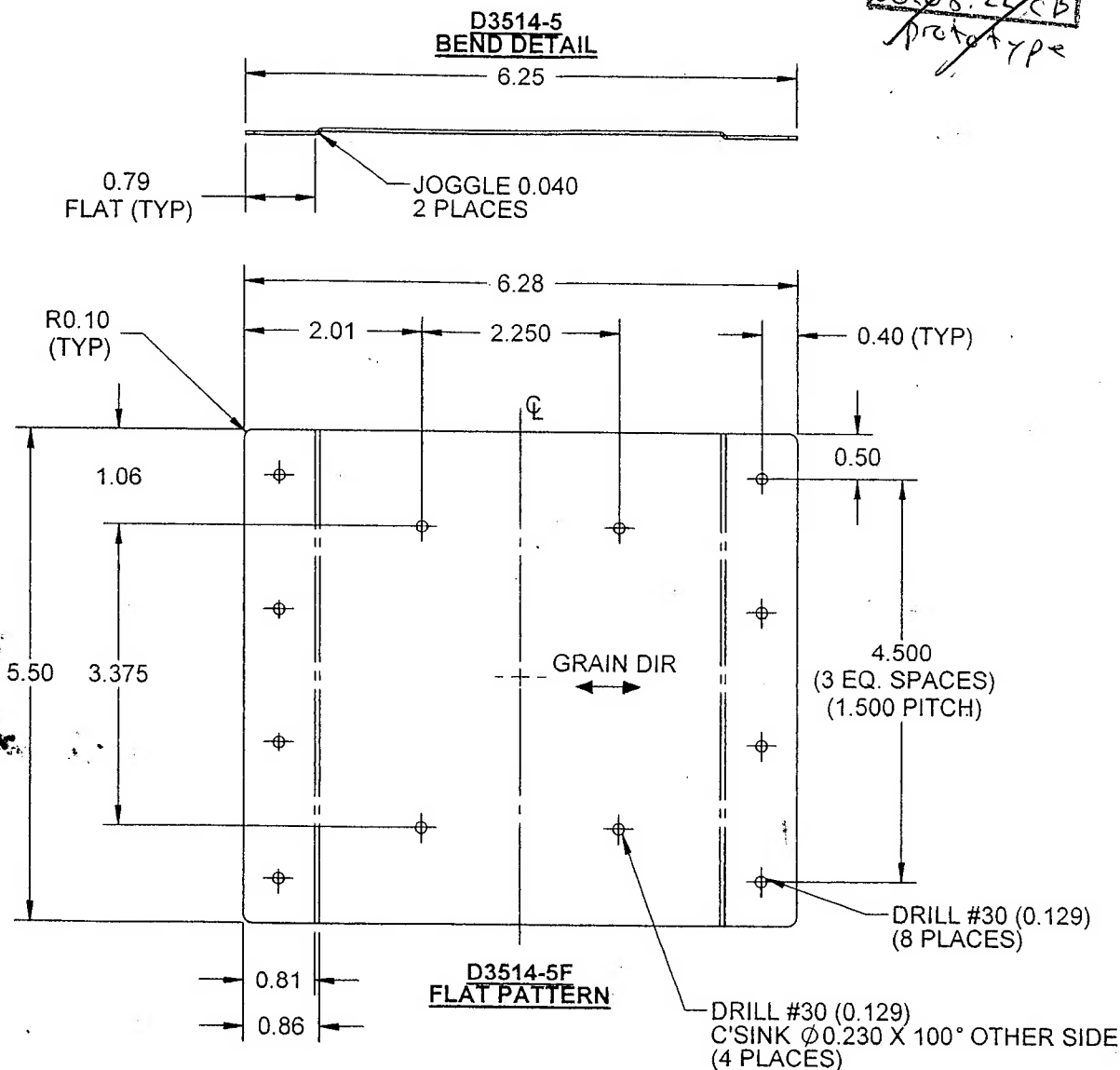
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SHEET 5 OF 7 SCALE 1:2

UNDER REVIEW

06.08.22 CB

prototype



D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART-SPEC-M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK BELOW JOGGLE

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 28357

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WORK ORDER		04/13/06 ORD		TEST RESULTS	
SHIP TO		DELIVERY DATE	SHIP BRANCH	SELL BRANCH	WORK ORDER
01		04/24/06 DEL	30 (04)	30-TOR	UZ3809
6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		Copper and Brass Sales Canada			
A ThyssenKrupp Materials NA company		ThyssenKrupp			
CUSTOMER P.O. NUMBER	TERRITORY	ENTRY ID	DATE:		
000001005	01	30BXT			
INSIDE SALES	INSIDE SALES TELEPHONE		QUANTITY	ORDERED	SHIPPED
INDA LACELLE	BRIAN TEDESCO		INVENTORY	54.19 LB	52.00
TELEPHONE	(905) 696-8100 37622		BILLING	2.00 PC	2.00
SHIP VIA	SHIPPING STATUS		WAREHOUSE		
COMPLETE	PARTIAL	CANCEL	PACKED WITH OTHER GOODS		
X			UZ3800		
CUSTOMER	FOB		FINISHED GOODS LOCATION		
COMMON/FRT-CCX	DEST		WARN LABEL:1001		
PPD			063496-4		

061 T6 FLAT ALUMINUM SHEET, 1.040 X 48 X 144
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 Dimensions., Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS											
Shipping, do not place any packages or goods on top of our material."											
SCRAP		FILLED BY		PACKED BY		Q/A AUDIT					
		SC									
MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT							
100		HAND, CRANE, FORK, DOCK		200							
WPS	CASES	CUSHP	PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT	COILS		
INSPECTION RECORD											

TEST RESULTS

CERTIFICATE OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 Our products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 1-800-244-233-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027	ASTM-B209	ROHS COMPLIANT	
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS : TAG NO	QUANTITY UOM VENDOR VEND PO HEAT/LOT
52.00 LB CORUS	0CC1837 7124901		

M-100742